

ASAP

Work Order ID 130161

130161

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February-25-15 8:24:42 AM

Item ID: D2622-120C Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Step Extrusion

Start Date: 2/25/15 Start Qty: 120.00 *120* Cust Item ID:

Required Date: 3/06/15 Req'd Qty: 120.00 *120* Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2622	Rev C1

100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>27690</u> a) Extrude as per Dwg D2622 Rev. Cb)								
	Material: 6061-T6 (QQ-A-200/8)c) Minimum yield tensile strength = 35								
	ksid) Minimum ultimate tensile strength = 38 ksi e) Minimum elongation =								
	8%f) Order at 120" longg) Bon L Canada Inc.								

CL 15/03/06 120

110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								

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120	QC18 In-Coming Inspection Material	0.00							
120									
QC	Memo	0.00							
Quality Control	Check Pull test per Dwg D2622 for compliance page attached Check hardness								
	with Webster tester								

(126) 15.03.26 DAS 9 9-89

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Required Date: 3/06/15 Req'd Qty: 120.00 *120* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA003</u>	0.00				<u>126</u>		<u>DL</u>	<u>15/3/30</u>
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00				<u>ML5</u>		<u>15-03-31</u>	
Quality Control									

15-3-30

Picklist Print

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February-25-15 8:24:41 AM

Work Order ID: 130161

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Parent Item: D2622-120C

D2622-120C

Parent Item Name: Step Extrusion

Start Date: 2/25/15

Required Date: 3/06/15

Start Qty: 120.00

Required Qty: 120.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2622-120CP

Purchased

No

110

Each

0.0000

1

120

D2622-120CP

Extrusion

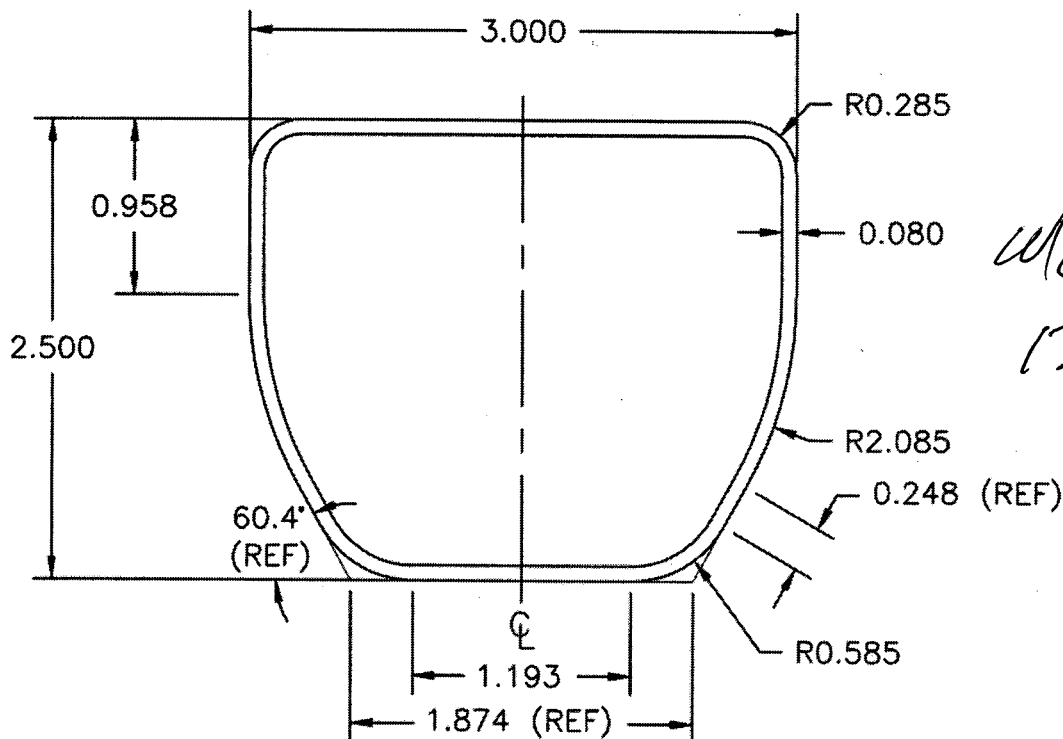
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126 SPB-03-25



RELEASED
02.09.11

DESIGN KE		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #		APPROVED #		DRAWING NO. D2622	
DATE 02.09.11		TITLE STEP EXTRUSION		REV. C SHEET 1 OF 1	
A		96.11.29		NEW ISSUE	
B		97.12.12		CHANGE MATERIAL, ADD TOL. QSI	
C		02.09.11		0.080 WAS 0.085; ADD PART & DIE No.	
CI		# CP 02.10.04		ADD 'REV. A' TO DIE NUMBER.	



D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES
(EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 Rev. A 
- 4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8%

- 5) PART IS SYMMETRIC ABOUT CENTERLINE
6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27690**

Purchase Order Date 3/6/2015

PO Print Date 3/6/2015

Page Number 1 of 2

Order From :

VC-BON001

SIGNATURE ALUMINUM CANADA INC.
C/O/ T10322C
P.O. BOX 4488, STN A
TORONTO, ON M5W 4H1
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905-427-6550

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D2622-120CP EXTRUDE AS PER DWG D2622 REV. C B130161 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS	Extrusion	3/24/2015 Yes 3/24/2015		120.00 Each	\$30.03	\$3,603.96
Line Total:							\$3,603.96
2	71401-45 Procurement Quality Clauses	PROCUREMENT QUALITY CLAUSES	3/24/2015 No 3/24/2015		1.00	\$0.00	\$0.00

Note:

3/6/2015

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

Cert Date	Cert No.	Sales Order	Page
03/21/2015	5351480	118003	1
Cust PO	B/L No.	Lot	Date
PO27690	019658	849018	03/23/15

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
001	DAA-897123-2	10FT MILL 6061 T6	D2622-120CP
Gross Weight	1,146 LBS		
Net Qty	1,111 LBS 126 PCS 2 PKGS		
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-08			

Mechanical Tests:

Tensile	Yield	% Elongation	Conductivity	HRE
MPA / KSI	MPA / KSI			
306.9 / 44.5	279.3 / 40.5	8.2	N/A	92

8915-03-25

Chemical Analysis:

SI	FE	CU	MN	MG	CR	ZN	TI	V
0.64	0.27	0.23	0.05	0.88	0.07	0.05	0.02	0.01

This Material is Made in Canada

This Material is RoHS Compliant

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Mazzotta
Director of Quality
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2622-120C
 DATE: 15-03-25

PO / BATCH NO.: 27690 / BB016

MATERIAL CERT REC'D: yes
 QUANTITY RECEIVED: 126
 QUANTITY INSPECTED: 126
 QUANTITY REJECTED: 0

THICKNESS ORDERED: .080
 THICKNESS RECEIVED: .080
 SHEET SIZE ORDERED: N/A
 SHEET SIZE RECEIVED: N/A

DESCRIPTION	NCR (Check Y/N)		COMMENTS
SURFACE DAMAGE	Y	☒	
CORRECT FINISH	☒	N	
CORROSION	Y	☒	
CORRECT GRAIN DIRECTION	☒	N	
CORRECT MATERIAL	☒	N	
CORRECT THICKNESS	☒	N	
PHOTO REQUIRED	Y	☒	
CORRECT MATERIAL	☒	N	
CORRECT REF # TO LINK CERT	☒	N	<u>1027690</u>
CORRECT MATERIAL IDENTIFICATION	☒	N	
CORRECT M# ON THE MATERIAL	☒	N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y	☒	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y	☒	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION		ENGINEERING SIGNOFF (if required)	
INSPECTED BY: <u>9-89</u>	SIGNED OFF BY: _____		
DATE: <u>15-03-25</u>	DATE: _____		

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in